












Date: Monday, 27/08/2007 3:44:44 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 34275	
Estimate Number : 10288	
P.O. Number : <i>N/A</i>	Part Number : D25771
This Issue : 27/08/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2577 REV E
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 33105	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 03/09/2007 Qty: 30 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: E 02.09.24 Re-format; Incorporated D2577-101/-11 KJ/ RF est F 06.09.11 now waterjet EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M1010S16GA 1010/1025/A21/6aA SHEET
	 <i>B 07-08-28</i> 
Comment: Qty.: 0.8474 sf(s)/Unit Total : 25.4205 sf(s) 1010/1025/A21/6aA SHEET <i>B# M105261</i>	
2.0	WATER JET FLOW WATER JET
	 
Comment: FLOW WATER JET 1-Cut as per Dwg D2577 (D2577-101 detail) Dwg Rev: <i>E</i> <i>B 07-08-28</i> <i>(33)</i> Prog Rev: <i>E</i>	
2-Deburr if necessary <i>B 07-09-13</i> <i>SAD</i> <i>07/08/27</i>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	 <i>B 07-08-28</i> 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SAD</i> <i>07/08/27</i>	
4.0	QC8 SECOND CHECK
	  <i>counts</i>
Comment: SECOND CHECK <i>E</i> <i>07/09/13</i> <i>(433)</i>	
5.0	BRAKE NC NC BRAKE
	 
Comment: NC BRAKE 1-Form on brake as per Dwg D2577 using DT8155 and DT8179 2-Form joggle as per Dwg D2577 using DT8157 3-Identify as D2577-1 <i>SB</i> <i>07/09/19</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: D Date: 07/11/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/08/2007 3:44:44 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 34275

Part Number: D25771

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Deburr if nesasary

*W/S*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Er 07/01/09*

*(33) counters*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

Batch

A/R 7560 Hardcoat Rod

*M105887*

*FC 07/11/06*

*(33)*

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 07-11-06*

*(33)*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*M105642*

*YI 07-11-06*

*(33)*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 07/11/07*

*(33)*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *EP-17*

*YI*

*07-11-04*

*(33)*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*20/11/09*

*(33)*

Job Completion



*U 07/11/08*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**



RELEASED  
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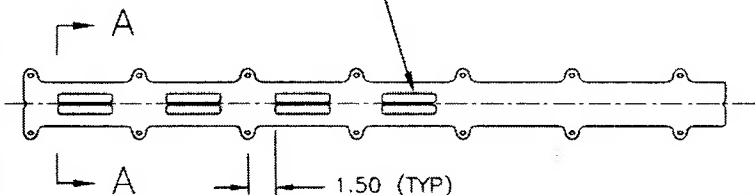
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CHECKED	APPROVED	DRAWING NO.
00.09.22	00.09.22	D2577
DATE	TITLE	SHEET 1 OF 5
00.09.22	WEARSHOE	SCALE 1:10
A	96.09.16	NEW ISSUE
B	96.12.04	ADD HARDCOAT WELDS
C	97.05.30	CHANGE HOLES TO OBROUNDS
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DEC9176

7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308

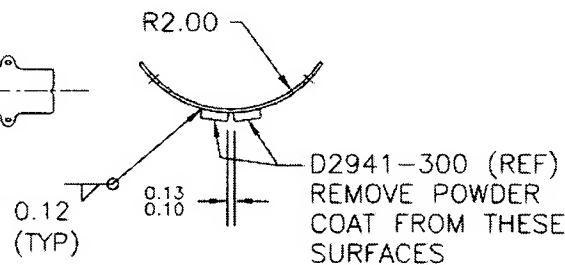


D2577-1 & D2577-3 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300  
SHWAYDER WEAPADS  
(8 PLACES)



SECTION A-A  
SCALE 1:5

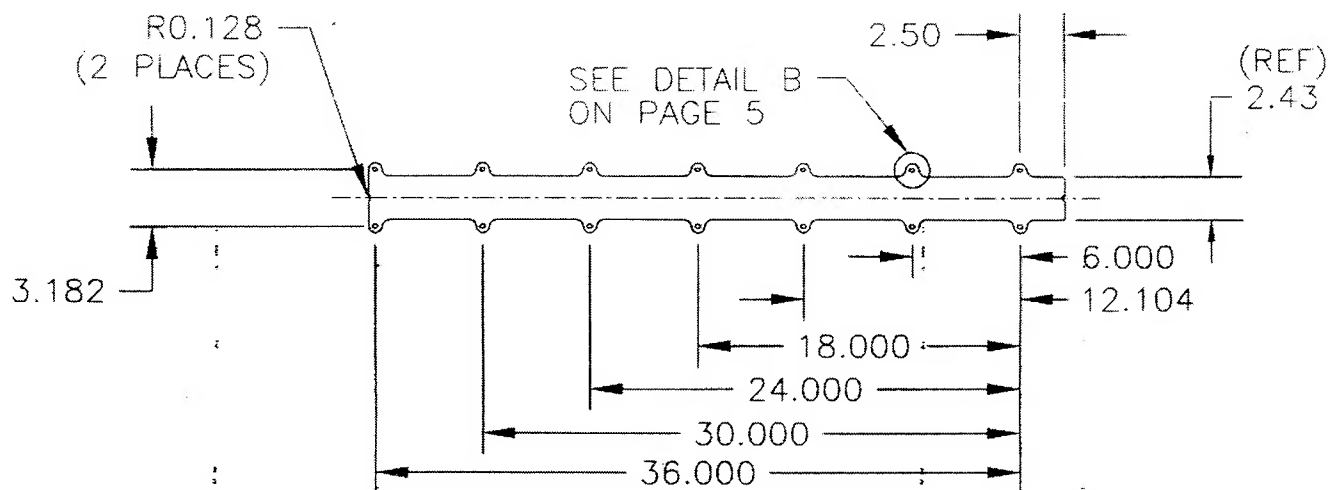


D2577-21 & D2577-23 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**



DESIGN	✓	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	
DATE	00.09.22	DRAWING NO.	D2577	REV. E
		TITLE	WEARSHOE	SHEET 2 OF 5
		SCALE	1:10	



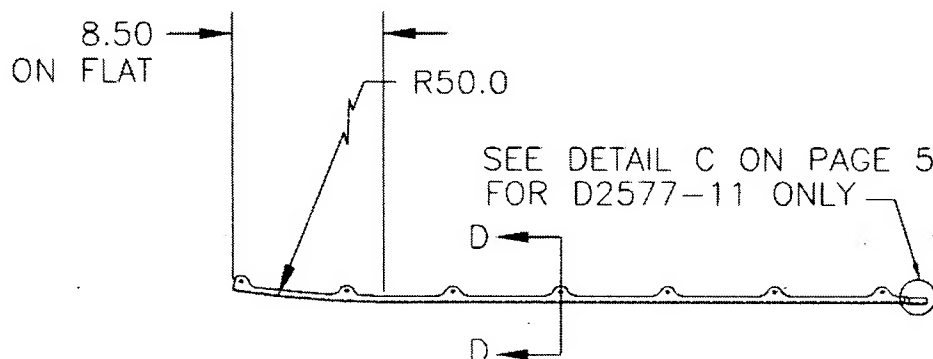
# D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



# D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

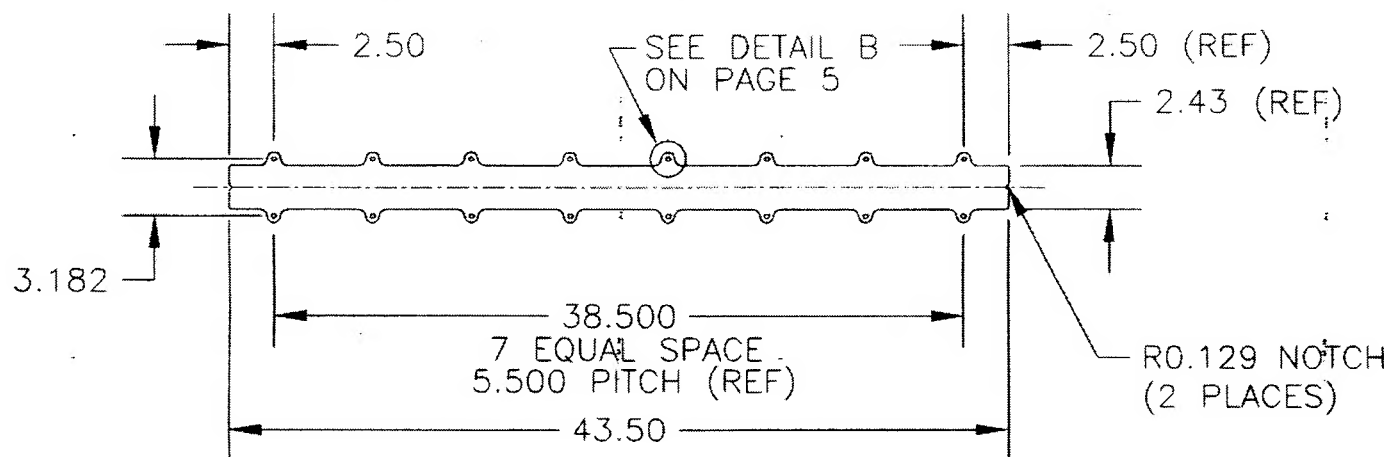
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**DART**

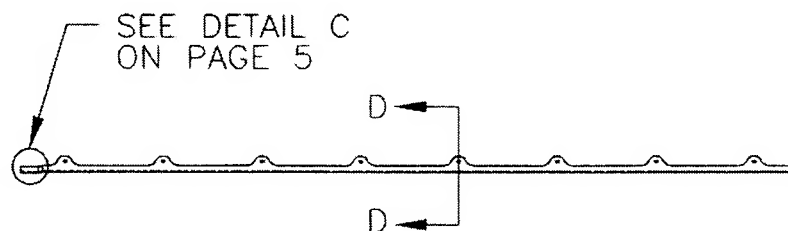


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CHECKED	APPROVED	DRAWING NO. D2577	SHEET 3 OF 5
DATE 00.09.22	TITLE WEARSHOE	SCALE 1:10	

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
00.01.26

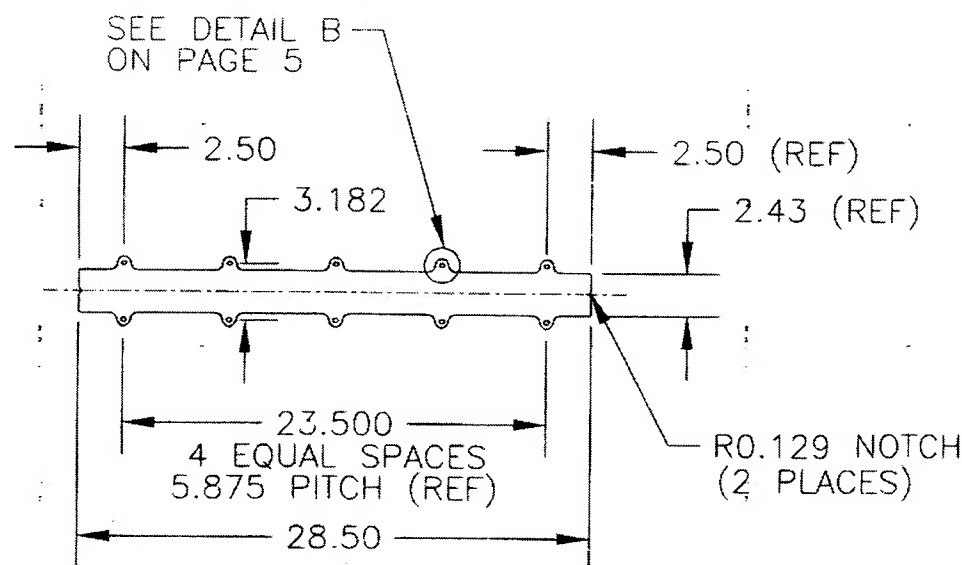
**DART**



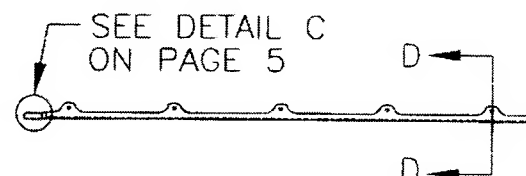
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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	DRAWING NO.
00.09.22	WEARSHOE	D2577
		REV. E
		SHEET 4 OF 5
	SCALE	1:10

RELEASED  
00 09 26 04

### D2577-7 FLAT PATTERN



### D2577-7 LONGITUDINAL BEND



### D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

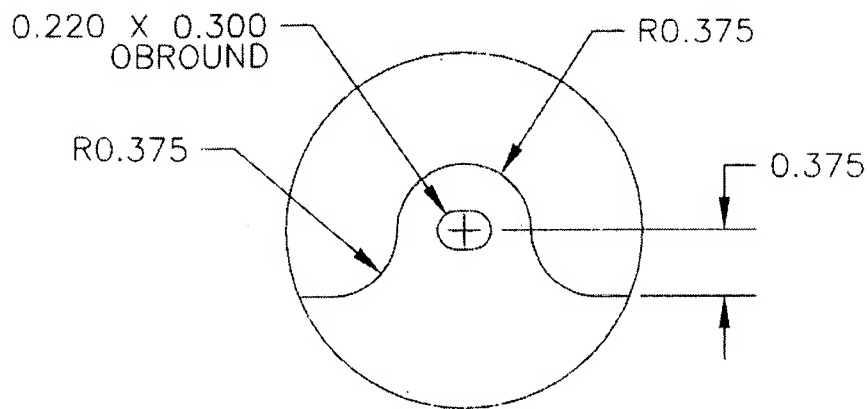




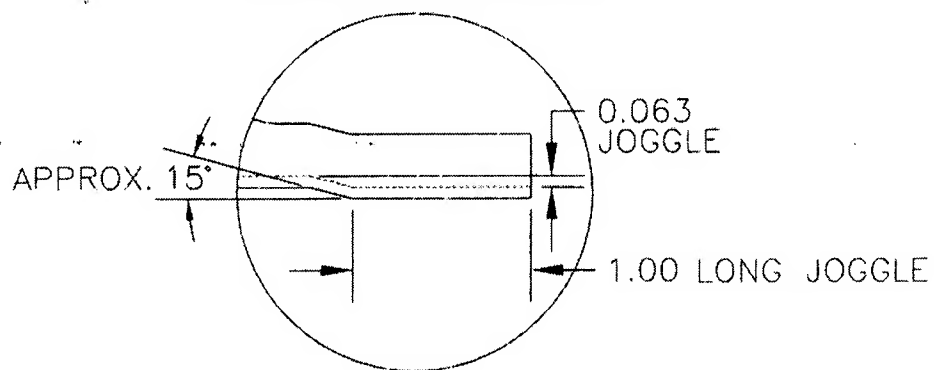
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CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED  
00.09.22

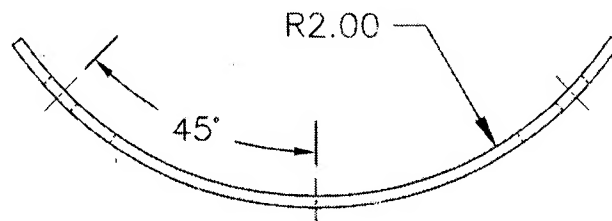
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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